

# Work Order ID 59630

Wednesday, June 09, 2010 8:43:12 AM



Page 1

Item ID:	D3793-1	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Wearshoe					
Start Date:	6/9/2010	Start Qty:	12.00		Cust Item ID:	
Required Date:	6/17/2010	Req'd Qty:	12.00		Customer:	
Reference:						

Approvals:	Process Plan:	<u>H</u>	Date:	<u>10-6-09</u>	Tooling:		Date:		Run	Start	
	QC:		Date:		SPC (Y/N):		Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr								
D3793	Rev A								

100		0.00							
	FLOW WATER JET								
Waterjet	Memo	0.00							
FLOW CNC Waterjet	1-Cut as per Dwg D3793 <input type="checkbox"/> Dwg Rev: <u>A</u> <input type="checkbox"/> Prog Rev: <u>A</u> <input type="checkbox"/> 2- Deburr if necessary								
304 .040									

AB 10-6-22

(13)

110		0.00							
	QC2- Inspect parts off machine FAI/FAIB								
QC	Memo	0.00							
Quality Control									

AB 10-6-22

120		0.00							
	QC8- Inspect parts - second check								
QC	Memo	0.00							
Quality Control									

8/10/22

(AB)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_






NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			



**NOTE:** Date & initial all entries




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Item ID: D3793-1	Accept		Setup	Start	
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Item Name: Wearshoe					
Start Date: 6/9/2010	Start Qty: 12.00		Cust Item ID:		
Required Date: 6/17/2010	Req'd Qty: 12.00		Customer:		
Reference:					

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130  Brake NC	NC BRAKE	0.00				(13)			
Brake NC	Memo 1-Deburr if necessary <input type="checkbox"/> 2-Form on Brake as per Dwg D3793 using Jigs <input type="checkbox"/> 3-Form Joggle on brake using Jig as per Dwg D3793	0.00							
140  QC	QC5- Inspect part completeness to step on W/O	0.00							
Quality Control	Memo	0.00				(73)			
150  Powdercoat	Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3	0.00							
Powder Coating	Memo 112588 START TIME: 11:45 322° FINISH TIME: 12:15	0.00							
						13			BR 10-6-08.

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

**Work Order ID 59630**

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Wednesday, June 09, 2010 8:43:12 AM

Item ID: D3793-1

Accept



Setup Start



Revision ID:

Item Name: Wearshoe

Stop



Start Date: 6/9/2010 Start Qty: 12.00



Cust Item ID:

Required Date: 6/17/2010 Req'd Qty: 12.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160  QC Quality Control	QC3- Inspect Part Finish  Memo	0.00  0.00				<u>ml</u>	<u>10</u>	<u>06</u>	<u>28</u> (13)
170  Packaging Packaging	Identify as per dwg & Stock Location: <u>FP-18</u>  Memo	0.00  0.00	<u>9J</u>	<u>10106129</u>		<u>13</u>	<u>0</u>		
180  QC Quality Control	QC21- Final Inspection - Work Order Release  Memo	0.00  0.00						<u>10/06/29</u>	<u>JD</u>

10/06/29

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Wednesday, June 09, 2010 8:43:17 AM

Page 1

Work Order ID: 59630



Parent Item: D3793-1



Parent Item Name: Wearshoe

Start Date: 6/9/2010

Required Date: 6/17/2010

Comments: IPP Rev:A 08-05-13 new issue DD verified by:EC  
IPP Rev:B 08-05-23 revA as per dwg DD verified by:EC

Start Qty: 12.00

Required Qty: 12.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S20GA		Purchased	No			100	sf	107.9836	0.5902	7.455158	7.6		



304/316 .040 Sheet



RB10-6-22

## Location

## Loc Qty

## Loc Code

MAT

104.1278

114574

104.1278

MAT20

3.8558

112885

2.7475

113062

1.1083

114574

(13)

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	59630
<b>Description:</b> Wearshoe		<b>Part Number:</b>	D3793-1
<b>Inspection Dwg:</b> D3793 <b>Rev:</b> A		<b>Page 1 of 1</b>	

### FIRST ARTICLE INSPECTION CHECKLIST

☒ **First Article**
                         
 ☐ **Prototype**

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.188	+0.005/-0.001	0.182	X			
0.300 x 0.300	+/-0.010	304 x 304	X			
1.885	+/-0.010	1.887	X			
2.000	+/-0.010	2.000	X			
5.00	+/-0.030	5.00	X			
8.00	+/-0.030	8.00	X			
14.00	+/-0.030	14.00	X			
20.00	+/-0.030	20.00	X			
14.066	+/-0.010	14.066	✓			
18.983	+/-0.010	18.983	✓			
23.900	+/-0.010	23.900	✓			
27.400	+/-0.010	27.400	✓			
29.400	+/-0.010	29.400	✓			
32.900	+/-0.010	32.900	X			
0.040	+/-0.010	0.036	X			

<b>Measured by:</b>	B
<b>Date:</b>	10-6-22

<b>Audited by:</b>	S
<b>Date:</b>	10/6/22

<b>Prototype Approval:</b>	N/A
<b>Date:</b>	N/A

<b>Rev</b>	<b>Date</b>	<b>Change</b>	<b>Revised by</b>	<b>Approved</b>
A	08.05.30	New Issue	KJ/DD	

W/O:			WORK ORDER CHANGES					
DATE	STEP		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

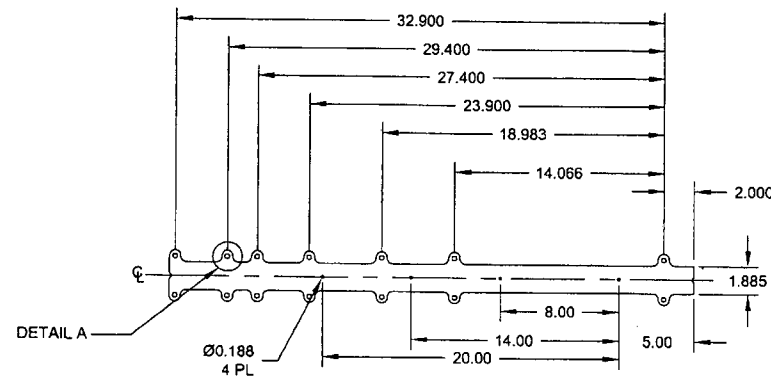
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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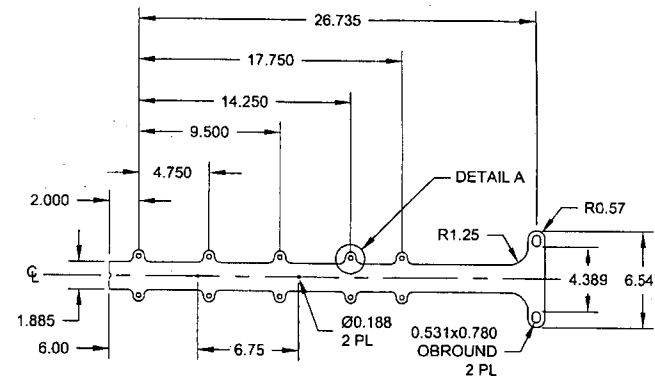
SHO...  
RET...  
ENGINEERING

UNCONTROLLED  
SUBJECT TO AMENDMENT  
WITH THE  
WORK ORDER  
NO. 39630

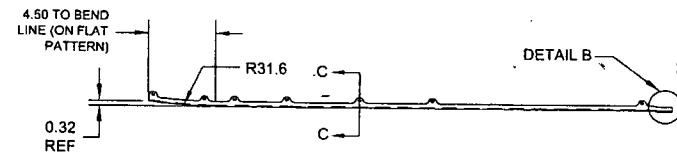
*PH 10-6-09*



**D3793-1F FLAT PATTERN**



**D3793-3F FLAT PATTERN**



**D3793-1 BEND DETAIL**  
(MAKE FROM D3793-1F)



**D3793-3 BEND DETAIL**  
(MAKE FROM D3793-3F)

**RELEASED**  
*08.05.14*

**NOTES:**

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK)  
(REF DART SPEC M304S20GA)
- 2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "DXXXX-X" ON INSIDE SURFACE USING FINE POINT PERMANENT INK MARKER OR LABEL AFTER FINISH
- 7) WEIGHT: D3793-1 - 0.72 LBS, D3793-3 - 0.66 LBS

REV.	DESCRIPTION	PH	DATE
A	NEW ISSUE	PH	08.05.14
DESIGN	PH	BY	DATE
DRAWN	PH		
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	08.05.14		

**DART AEROSPACE USA, INC**  
PORT HADLOCK, WA  
DRAWING NO. D3793  
TITLE WEARSHOE  
REV. A  
SHEET 1 OF 2  
SCALE NTS  
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

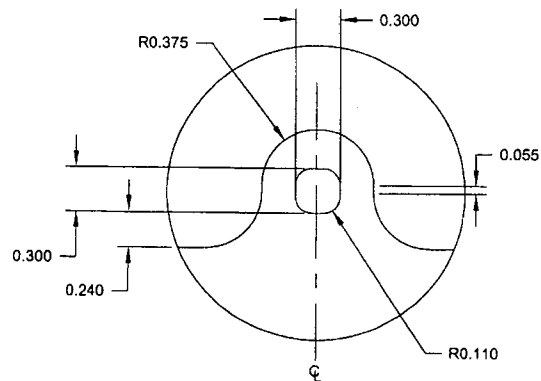
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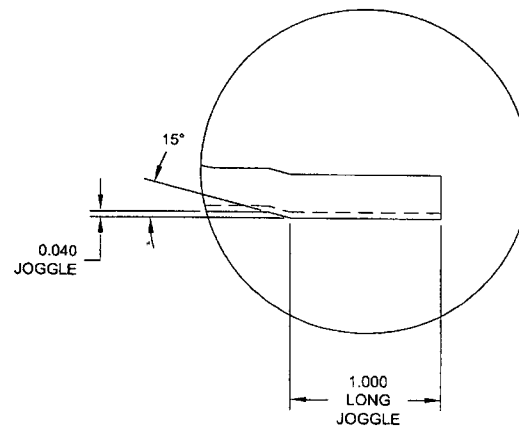
NOTE: Date & initial all entries

8 7 6 5 4 3 2 1

D



**DETAIL A**  
SCALE 10X

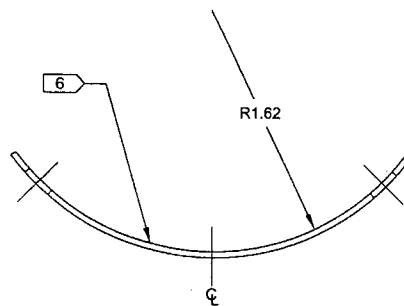


**DETAIL B**  
SCALE 10X

u b 59030

C

B



**SECTION C-C**  
SCALE 10X

**RELEASED**  
08-05-14

A

DESIGN	PH	<b>DART AEROSPACE USA, INC</b>	
DRAWN	PH	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.	<del>PH</del>	D3793	SHEET 2 OF 2
APPROVED	<del>PH</del>	TITLE	SCALE
DE APPR.	<del>PH</del>	WEARSHOE	NTS
DATE	08.05.14	COPYRIGHT © 2008 BY DART AEROSPACE USA, INC	
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8 7 6 5 4 3 2 1

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